

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-024571**Date Inspected:** 05-Jun-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See Below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

CWI Inspector: Mr. Li Peng Fei

On this date CALTRANS OSM Quality Assurance (QA) Inspector, Mr. Paul Dawson, arrived on site at the Zhenhua Port Machinery Company (ZPMC) facility at Changxing Island, in Shanghai China, for the purpose of monitoring welding and fabrication of the San Francisco / Oakland Bay Bridge (SFOBB) components. This QA Inspector observed the following:

OBG Trial Assembly

This QA Inspector observed ZPMC welder Mr. Yang Xuhe, stencil 057795 used shielded metal arc welding procedure WPS-B-P-2212-U4B-FCM-1 to make OBG segment 14 cross beam weld CB3003A-019-003. This QA Inspector observed a welding current of approximately 180 amperes (amps), the base material had been preheated with a torch and Mr. Yang Xuhe appeared to be certified to make this weld. Items observed on this date appeared to generally comply with applicable contract documents.

This QA Inspector observed ZPMC welder Mr. Wang Guijun, stencil 067275 used shielded metal arc welding procedure WPS-B-P-2212-FCM-1 and WPS-B-P-2214-FCM-1 to make segment 14W welds OBW14A-010 and 011. This QA Inspector observed a welding current of approximately 140 amps the base material had been preheated with a torch and Mr. Wang Guijun appeared to be certified to make these welds. Items observed on this date appeared to generally comply with applicable contract documents.

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This QA Inspector observed ZPMC welder Mr. Xu Kesong, stencil 070009 used shielded metal arc welding procedure WPS-B-P-2212-FCM-1 and WPS-B-P-2214-FCM-1 to make segment 14W welds OBW14A-012 and 013. This QA Inspector observed a welding current of approximately 160 amps the base material had been preheated with a torch and Mr. Xu Kesong appeared to be certified to make these welds. Items observed on this date appeared to generally comply with applicable contract documents.

This QA Inspector observed ZPMC welder Mr. Jiang Zhen, stencil 068917 used shielded metal arc welding procedure WPS-B-P-2212-FCM-1 and WPS-B-P-2214-FCM-1 to make segment 14W welds OBW14A-012 and 013. This QA Inspector observed a welding current of approximately 150 amps the base material had been preheated with a torch and Mr. Jiang Zhen appeared to be certified to make these welds. Items observed on this date appeared to generally comply with applicable contract documents.

This QA Inspector observed ZPMC welder Mr. Wang Rucheng, stencil 066881 used shielded metal arc welding procedure WPS-B-P-2212-FCM-1 and WPS-B-P-2214-FCM-1 to make segment 14W welds OBW14A-014 and 015. This QA Inspector observed a welding current of approximately 150 amps the base material had been preheated with a torch and Mr. Wang Rucheng appeared to be certified to make these welds. Items observed on this date appeared to generally comply with applicable contract documents.

At around 22:15 hours ZPMC moved OBG segments 13W-A, B and C away from segment 14W for a distance of approximately twenty meters. See the photograph below for additional information.



Summary of Conversations:

See Above.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact James Devey +8615000026784, who represents the Office of Structural Materials for your project.

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Inspected By: Dawson,Paul

Quality Assurance Inspector

Reviewed By: Riley,Ken

QA Reviewer